

Work Order ID 50573

July 16, 2009 8:14:55 AM



Page 1

Item ID: D2989-4

Revision ID: D

Item Name: Rib

Start Date: 07/17/2009 Start Qty: 2.00



Required Date: 07/22/2009 Req'd Qty: 2.00



Accept



Setup Start



Stop



Reference:

Approvals: Process Plan: *MF*

Date: 09-07-16 Tooling:

Cust Item ID:

Customer:

QC:

Date: SPC (Y/N):

Date:

Date:

Run Start



Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2989	Rev D

100

0.00



Large Fab

Large Fab

Memo

0.00

1- pick D3166-3 cut D2989-4 to length using DT9441 template and cut 45
degree as per dwg D2989 12- remove identification markings! 13- deburr

SAD 09-07-20

110



QC5- Inspect part completeness to step on W/O

0.00

=>

S 09/07/20



f

QC

Quality Control

120



Identify as per dwg & Stock Location: _____

0.00

Basket cell

Memo

0.00

8/1 09/07/20 2x

Packaging

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2989-4

Accept



Setup Start



Revision ID: D

Stop



Item Name: Rib

Start Date: 07/17/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 07/22/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

09/07/20 AF

MF 09-07-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

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Work Order ID: 50573



Parent Item: D2989-4RevD



Parent Item Name: Rib

Start Date: 07/17/2009

Required Date: 07/22/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3166-3RevA1		Manufactured		No		100	Each	8.0000	0.1684			

Basket Hoop



Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA	8
48429	2
50033	6

0.1684 SPA
09-07-20 QTY 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

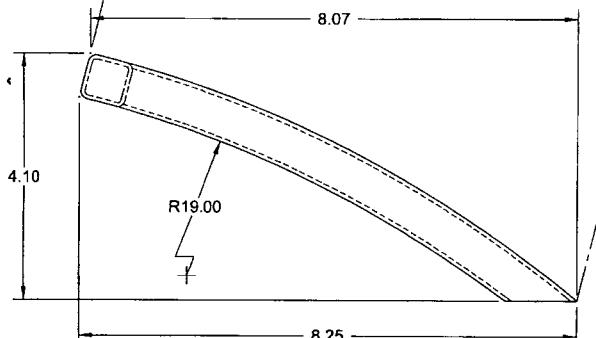
WORK ORDER

NO. 50573

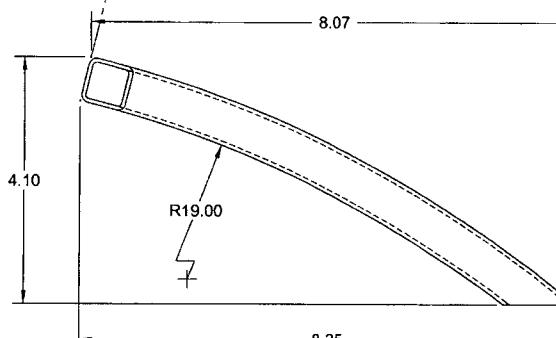
mf 09-07-16

0.75 X 45°
CHAMFER

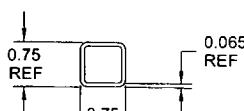
0.75 X 45°
CHAMFER



D2989-3 RIB



D2989-4 RIB



TYPICAL SECTION
VIEW

NOTES:
1) MATERIAL: D3166-3 BASKET HOOP
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT: D2989-3/4 = 0.39 lbs;

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D2989
CHECKED	<i>AB</i>	REV. D
MFG. APPR.	<i>AB</i>	SHEET 4 OF 5
APPROVED	<i>AB</i>	TITLE
DE APPR.	<i>AB</i>	SCALE
DATE	08.09.24	NTS

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08/11/18 AD